

Starting feed per tooth f_z for HELISLOT 09 slotting mills with inserts XNMU 09...

Workpiece Material						f_z (mm/t)		
ISO class DIN/ISO 513	Description	Typical representative		Hardness, HB	ISCAR mat. group**	Grades		
		AISI/SAE/ASTM	DIN W.-Nr.			IC808	IC5400	IC830
P	Non-alloy steel	1020	1.0402	130-180	1	0.1-0.25	0.1-0.25	0.1-0.25
	Alloy steel	4340	1.6582	260-300	8	0.1-0.2	0.1-0.2	0.1-0.2
	Alloy steel	4340	1.6582	HRC 35-42*	9	0.1-0.15	0.1-0.15	0.1-0.18
	High alloy steel	H13	1.2344	200-220	10	0.1-0.2	0.1-0.2	0.1-0.2
	Martensitic s.s.	420	1.4021	200	12	0.1-0.2	0.1-0.2	0.1-0.2
M	Austenitic s.s.	304L	1.4306	200	14	0.1-0.15	0.1-0.15	0.1-0.15
	Austenitic s.s.	316L	1.4404	140	14	0.1-0.15	0.1-0.15	0.1-0.2
K	Grey cast iron	Class 40	0.6025 (GG25)	250	16	0.1-0.3		
	Nodular cast iron	Class 65-45-12	0.7050 (GGG50)	200	17	0.1-0.25		
H	Hardened steel	H11	1.2343	HRC 45-49	38.1	0.06-0.12	0.06-0.12	0.06-0.12
		P20	1.2330	HRC 50-55	38.2	0.05-0.1	0.05-0.1	0.05-0.1

* Quenched and tempered

** ISCAR material group in accordance with VDI 3323 standard

*** Recommendation for side slotting